

Date: Thursday, 4/12/2007 9:33:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIVOT ARM
Job Number : 31778	
Estimate Number : 12771	
P.O. Number : N/A	Part Number : 41232 200 002 005
This Issue : 4/12/2007 S.O. No. : N/A	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31021	Material : N/A
Written By : <u>H07.04.12</u>	Due Date : 5/10/2007 Qty: 8 Um: Each
Checked & Approved By : <u>H07.04.12</u>	
Comment : Est Rev:A New Issue 07-03-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1250	2024-T3 Round Bar 1.250"
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Comment: Qty.: 0.3675 f(s)/Unit Total : 2.9400 f(s)
 2024-T3 Round Bar 1.250"
 Batch: 103753

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 Turn as per Dwg 41232-200-0021

BC 07-04-30 (9)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-04-30 (9)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Mill as per Dwg 41232-200-002

2-Deburr

BC 07-05-01 (9)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-05-01 (9)

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/05/01 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:11 AM

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Process Sheet

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Drawing Name: PIVOT ARM

Job Number: 31778

Part Number: 41232 200 002 005

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 3680

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C207105102 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C207105102 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C207105102 (9)

10.0

MS21209F410

heli-coil



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HeliCoil 1/4"-28NF(RED)

Batch: M104030

SB 07/05/14 (9)

11.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg 41232-200-005.

MF 07-05-15 (9)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/15

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock


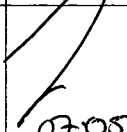


Location: GA

SB 07/05/15 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/16	1	2 Helicoid MS 21 2081-410 were snap traced were red broken with traced	 QS/042	Re head install helicoid.	SP 07/05/16	 07-05-15	 QS/042	 07-05-15

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 31778

Part Number: 41232 200 002 005

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



9

Comment: FINAL INSPECTION/W/O RELEASE

15/07/05/16

Job Completion



U 07-05-16

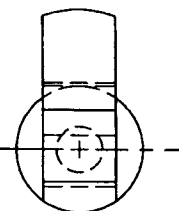
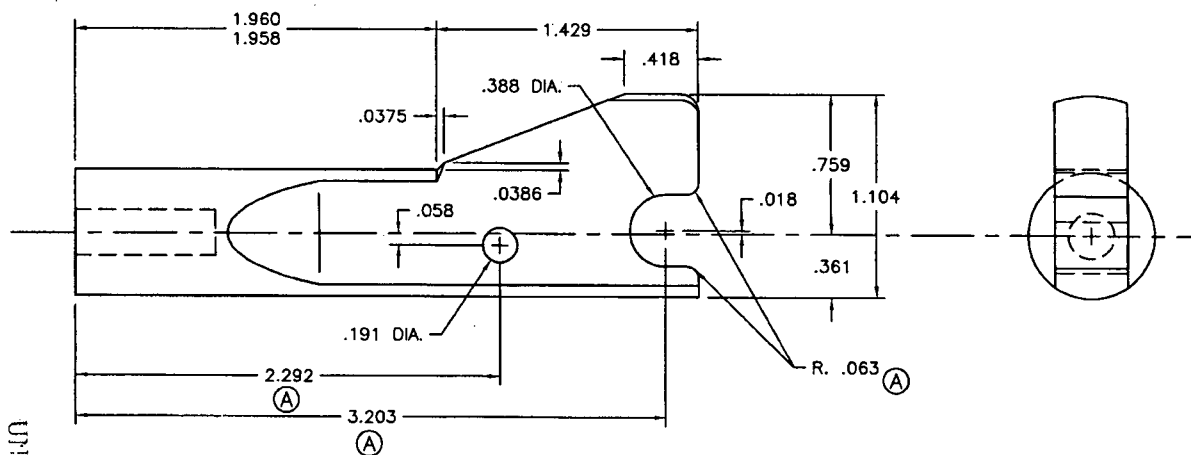
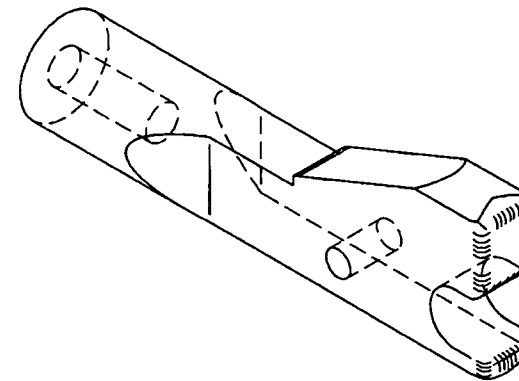
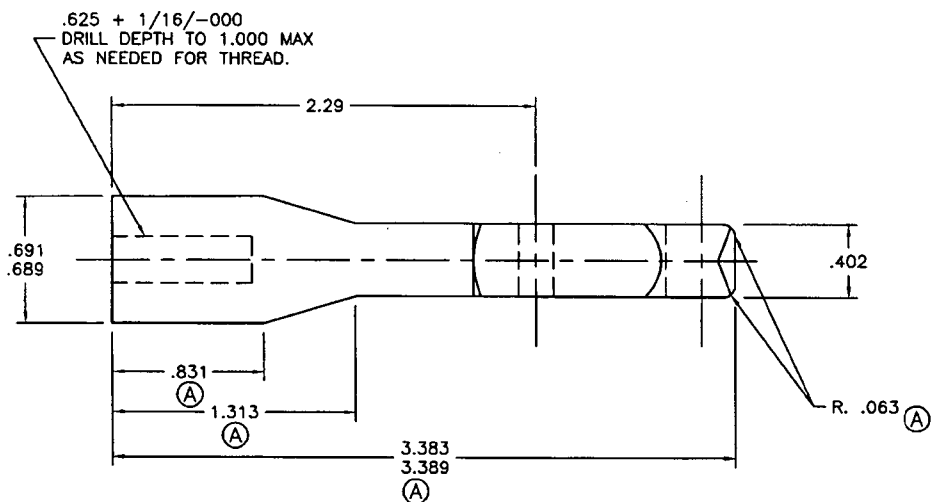
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



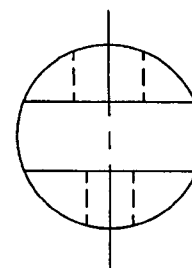
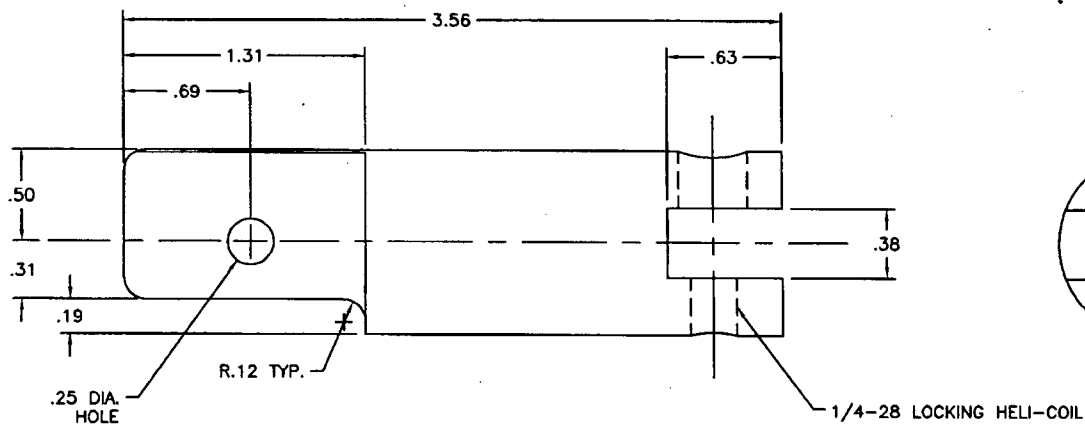
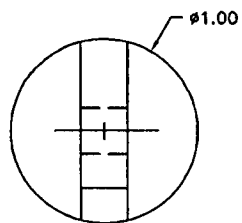
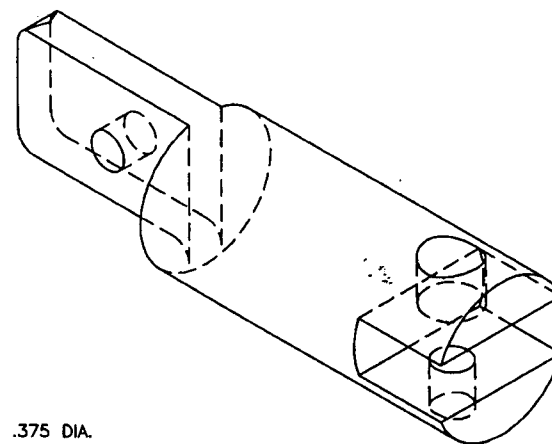
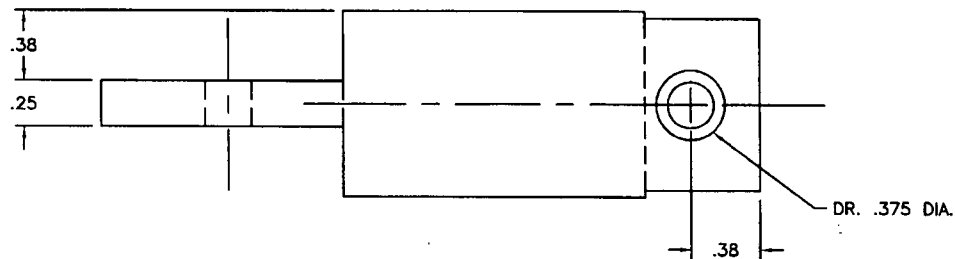
-003 LATCH

SHOP COPY
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WORK ORDER
NO. 31778

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Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

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Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 3 OF 3	A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

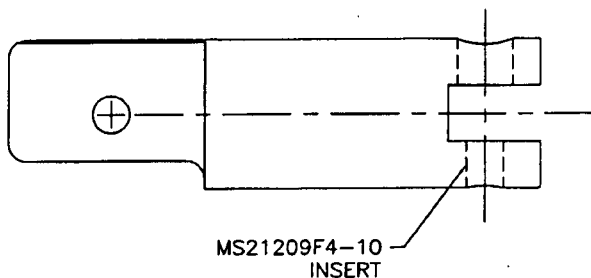
IS

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WAS

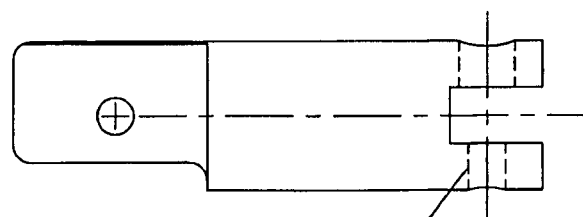
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IS



-005 PIVOT ARM

WAS



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WORK ORDER
NO. 31778

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				



DART AEROSPACE LTD		Work Order: 31778
Description: Crosstube Assembly <i>Stop Actuator</i>		Part Number: 41232-200-002-605
Inspection Dwg: 41232-200-002 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.38	$\pm .03$.373	✓		
	.25	"	.253	✓		
	.38	"	.384	✓		
	φ .375	$\pm .007$.378	✓		
	.31	$\pm .03$.308	✓		
	.50	"	.502	✓		
	.69	"	.693	✓		
	1.31	"	1.31	✓		
	3.56	"	3.556	✓		
	.63	"	.628	✓		
	.38	"	.385	✓		
	12.12	"	.120	✓		
	.19	"	.188	✓		
	φ .25	$\pm .006$ $\pm .001$.252	✓		
	1.00	$\pm .03$.999	✓		
SIDE B						

Measured by: BG	Audited by: JA	Prototype Approval:	N/A
Date: 07.05.01	Date: 07.05.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM**ANODISATION et PEINTURE TNM INC.****FACTURE
INVOICE**

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

55027**04-May-2007****CLIENT / CUSTOMER:**

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:**

PO00003680**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	QUANTITE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	26	26	VARIOUS - VARIOUS	\$0.00	\$0.00
			D 41232 - 200 - 002 - 005 B31778		
			LOT PRICE		\$130.00
				SUB TOTAL:	\$130.00
				TPS/GST:	\$7.80
				TVQ/PST:	\$0.00
				TOTAL AMOUNT DUE:	\$137.80

BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

No de TPS / GST # : 891559734 RT
No de TVQ / QST # : 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.